

Date: Wednesday, 21/01/2009 7:38:29 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MALE EYE
Job Number	: 45000		
Estimate Number	: 12061		
P.O. Number	:	Part Number	: PB6743001135
This Issue	: 21/01/2009 S.O. No. :	Drawing Number	: B6743001 PAGE28
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 40022	Material	:
Written By	:	Due Date	: 27/01/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>MF 09-01-21</u>		
Comment	: Est. B 05.10.14 Removed powder coat & added step 5 KJ/EC Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.2100 f(s)/Unit Total : 2.1000 f(s)

ROUND BAR 1.00"

Turn as per Dwg B67-43001

Dwg Rev: _____

Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)

(M6061T6R1.000)

Identify for B67-43001-135

Batch: 101417 (1,000) SK

MF 09/02/07

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE

1- Turn as per Folio FA Rev: n/a & Dwg B67-43001-1 Rev: B1

2-Deburr per dwg B67-43001-1

MF 09/02/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MF 09/02/08 (10)

MF 09/02/08 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-135 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: 12 Date: 05/03/04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12 Date: 05/03/04

NCR: <u>45000</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>02/07/04</u>	<u>2</u>	<u>E.M. pull out of collet</u> <u>.250 +0.0 - .005 under</u> <u>tolerance (x4)</u> <u>1. CB program error.</u>	<u>[Signature]</u>	<u>slow feed faster speed.</u> <u>Scrap + replace.</u>	<u>[Signature]</u> <u>05/03/04</u>	<u>[Signature]</u> <u>0503-03</u>	<u>[Signature]</u> <u>0503-03</u>	<u>[Signature]</u> <u>0503-03</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MALE EYE

Job Number: 45000

Part Number: PB6743001135

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mf

09/03/03 *(x10)*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

mf

09-03-03

(x10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *446A*

9/3/3

(ok)

SE

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/04

Job Completion



mf
09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

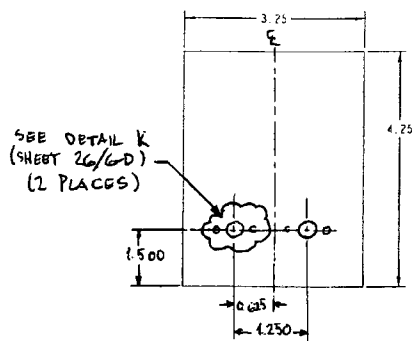
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

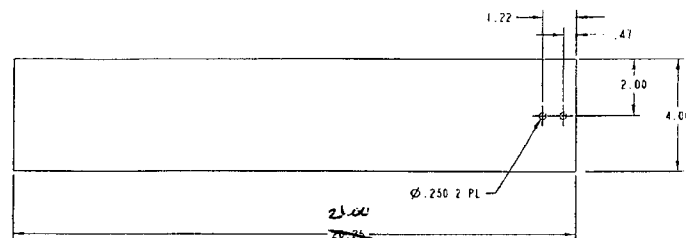
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

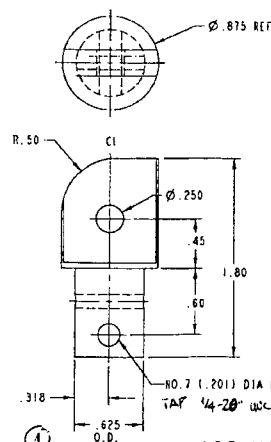
RELEASED



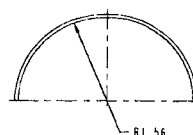
② -191 D-PAD BACK PLATE $\frac{1}{16}$ "
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000



② -177 SHORT SUPPORT PLATE $\frac{1}{16}$ "
MATERIAL: .090 THK, 6061-T6, QQ-A-250/11
SCALE 0.500



① JCM
-135 MALE EYE $\frac{1}{16}$ "
MATERIAL: .075 DIA, 6061-T6, QQ-A-200/8
SCALE 2.000



② -195 D-PAD FACE PLATE $\frac{1}{16}$ "
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE 1.000

45000

PREMIER AVIATION, INC.
3051 American Parkway, Grand Prairie, Texas 75050
D. OSUV8 B67-43001 81
SHEET 28 OF 45

ORIGINAL